

# Work Order ID 68273

Monday, April 11, 2011 11:14:53 AM



Page 1

Item ID: D4150-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm Plate

Start Date: 4/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MP Date: 11-04-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4150	B								

100		0.00							
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Waterjet	Memo	0.00							
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FLOW CNC Waterjet

304 .125

Cut as per dwg D4150  
Prog Rev: B  
Dwg Rev: B

Deburr as required

11-4-11

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							
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Quality Control

11-4-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 68273

Monday, April 11, 2011 11:14:53 AM



Page 2

Item ID: D4150-3

Accept



Setup Start



Revision ID:

Item Name: Arm Plate

Stop



Start Date: 4/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

5/10/12



Quality Control

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/4/12

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13

11/04-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 11, 2011 11:14:58 AM

Page 1

Work Order ID: 68273



Parent Item: D4150-3



Parent Item Name: Arm Plate



Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	15.5000	0.0254	0.160421			
304/316 0.125 Sheet												12-4-11	

Location

Loc Qty

Loc Code

MAT020

15.5

116623

15.5

116623

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

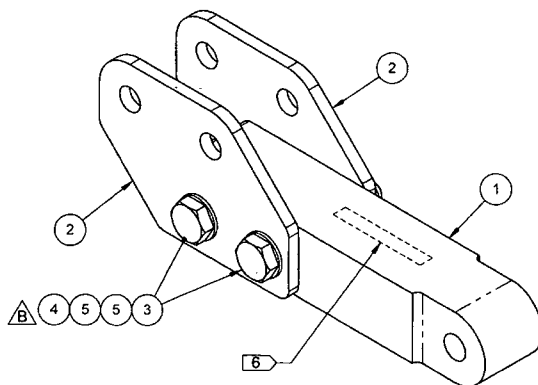
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**D4150-041 ATTACHMENT ARM ASSY**

ITEM	QTY	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48273

*11-04-11*

**RELEASED**  
2010-07-16  
*MB*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C8-2, C7-2, B4-3 & B5-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>ATTACHMENT ARM ASSY</b>	
DATE	10.07.08	NTS	

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

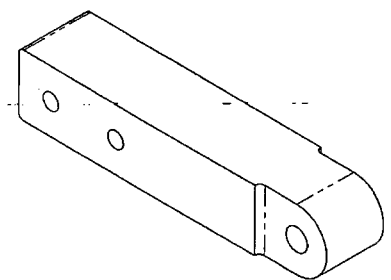
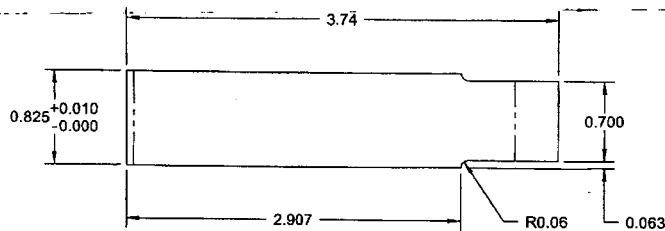
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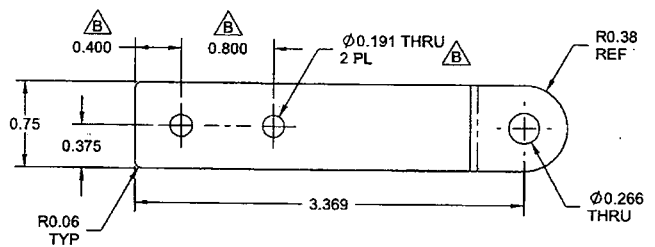
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D



C



B

**D4150-1 ARM**

*W/O 68273*

**RELEASED**  
2010-07-16  
*MP*

A

- NOTES:**  
 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
 REF DART SPEC M304B OR M303B  
 2) FINISH: NONE  
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.60 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4150</b>	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE <b>ATTACHMENT ARM ASSY</b>	SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	<b>10.07.08</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

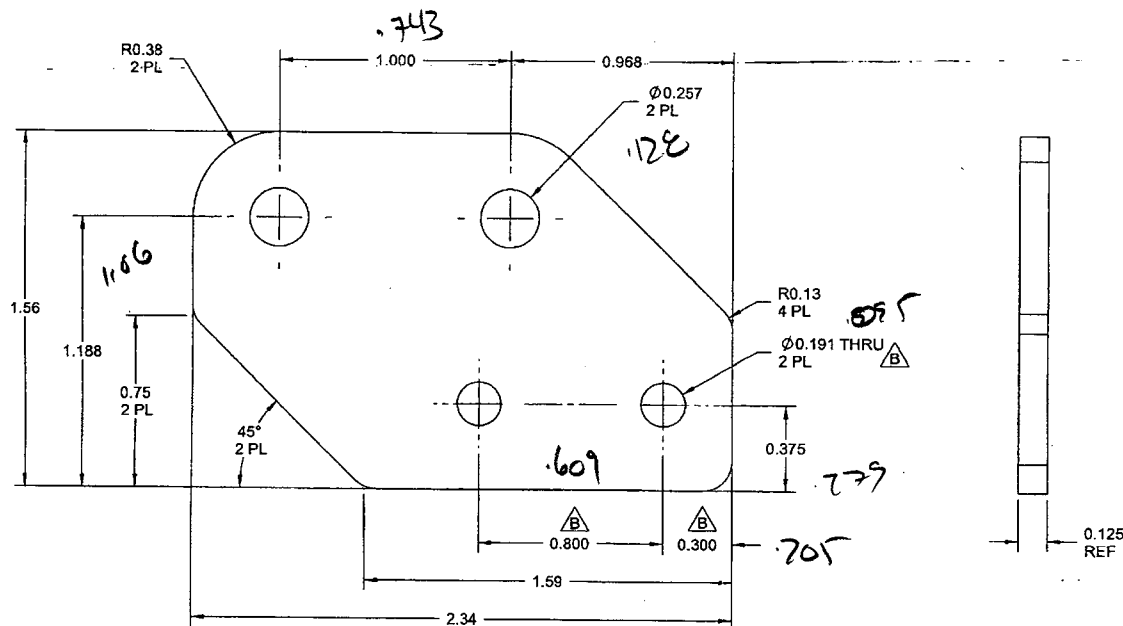
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**NOTE:** Date & initial all entries



**D4150-3 ARM PLATE**

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4150</b>	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>ATTACHMENT ARM ASSY</b>	SCALE
DE APPR.			NTS
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